

**(19) World Intellectual Property Organization
International Bureau**



(43) International Publication Date
7 February 2002 (07.02.2002)

PCT

(10) International Publication Number
WO 02/09925 A1

(51) International Patent Classification⁷: B29C 45/14

(74) Agent: **DENK, Paul, M.**; 763 South New Ballas, St. Louis, MO 63141 (US).

(21) International Application Number: PCT/US01/23278

(22) International Filing Date: 24 July 2001 (24.07.2001)

(81) Designated States (national): AU, CA, CN, ID, IL, IN, JP, KR, MX, SG, ZA.

(25) Filing Language:

English

(84) Designated States (regional): European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR).

(26) Publication Language:

English

(30) Priority Data:

09/629.746

31 July 2000 (31.07.2000) US

Published:

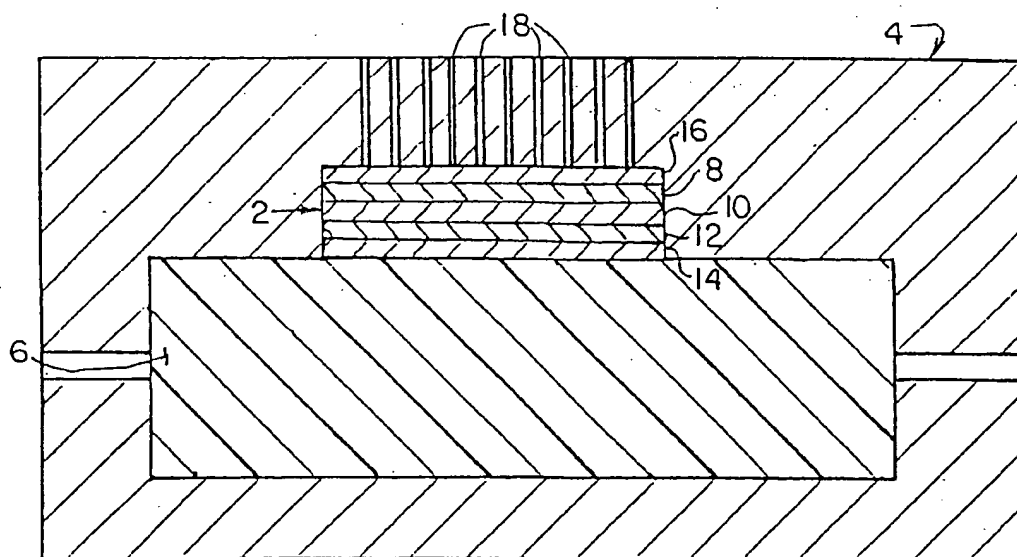
— with international search report .

(71) Applicant and

(72) **Inventor:** ABRAMS, Louis, B. [US/US]; P.O. Box 41, Fort Collins, CO 870522-0041 (US).

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(54) Title: CO-MOLDED FLOCK TRANSFER AND METHOD



(57) **Abstract:** A method of providing a molding article with a plush surface is provided. The method includes providing a flocked transfer (2), securing the transfer (2) in place in a mold (4), and molding the article such that the transfer (2) is embedded in the surface of the article. The article can be injection molded.

CO-MOLDED FLOCK TRANSFER AND METHOD

Technical Field

This invention relates to molded articles having flocked surfaces, and, in particular, to a new and improved method of applying flocked transfers to molded products.

Background Art

It's often desirable to decorate molded plastic parts for aesthetic or practical purposes. Injection molded articles are often decorated using inks, screen printing, pad printing, direct electrostatic flocking and hot stamping. These methods are most often post-molding operations requiring additional processing and cost and time. In addition, the resulting quality of the product is often low, due to the low quality of adhesion or unevenness of the coating.

Recently In-Mold Decoration has been developed to incorporate the application of decoration while the part is being molded to eliminate the extra step; however, a number of problems have developed with this technology that relate to the inability of the ink or decoration to remain stable during the heat and force of injecting the resins into the mold, that relate to the difficulty of getting the inserted decoration to stay in place, and which may relate to the decoration surface becoming smeared, crushed, or otherwise disturbed during injection molding.

Summary of the Invention

The present invention uses flock heat transfer type media rather than ink-printed film inserts in order to provide a plush, evenly-coated, three-dimensional textured decoration molded together with the hot resins when the part is formed. Using flock transfer media, a plushly textured decoration is permanently attached to the surface of the molded part. In order to accomplish this the hot melt adhesive commonly used with flock heat transfer manufacturing is eliminated so it will not liquefy and ooze out around the decoration in the mold. In addition, another adhesive, such as

-3-

stable sheet 8 to which a conventional flock transfer release adhesive 10, usually silicone wax, is applied in the reverse of a desired pattern or with overall coverage of the sheet, corresponding to the overall image which is to be flocked and transferred. The flock 12 which may be rayon or any other type of material with a conductive finish such as nylon, polyester or the like is applied to the activated adhesive 10 in any conventional manner, such as, conventional electrostatic means, vibration, air flow or gravity. The method of applying the flock 12 to the adhesive 10 depends on the transfer to be achieved – will the transfer be one color or several colors, will the transfer include any non-flock decorations, etc. Thus, the transfer itself, can be a conventional flock transfers, Lextra or Lextra 3-D type transfer, flocked roll goods such as made by Societe D' Enduction et de Flokage, located in Laval, France, from which pieces may be cut out and even pre-formed to fit better into molds where the surface of the finished product is not flat. The lower ends of the flock 12 are coated with a permanent binder adhesive 14 such as a water based latex which binds the flock into a unit. The binder 14 may contain an additional adhesive, for promoting the adhesion of the transfer to the resin in molding.

A relatively weak pressure-sensitive adhesive 16 can be added to the carrier film 8 in a separate layer, for the purpose of helping to locate the flock transfer 2 in position inside the mold 4 if no mechanical device is available.

FIGS. 1 and 2 illustrate the application of the transfer 2 to a molded article 6 during the molding process. The transfer 2 is positioned in the mold 4 using the pressure-sensitive adhesive 12. Other methods, such as the use of a vacuum, can be used to hold the transfer 2 in place in the mold 4 during the molding operation. Vacuum holes 18 are shown in the mold 4 which pass through the mold body. As seen, the transfer 2 is in contact with the vacuum holes 18. A vacuum can be drawn through the holes 18 to hold the transfer 2 in place. The flock transfer needs to be

release adhesive 10 are peeled off the fibers 12 to reveal a finished, flocked, surface on the newly molded part.

As an alternative to the invention as described above, it is likely that the flock 12 can be held by other means, to the molded polymer part 6, as follows. While the various release sheets, and release adhesive, may be initially applied to the upper surface of the flock layer, to hold it in position, during molding, rather than utilizing a permanent binder adhesive 14, to hold the flock within or to the molded part, there may be used a thermal setting polyester, such as available from Bostik, Inc., to permanently adhere the ends of the flock material thereto, and likewise, such a sheet will be cross linked into permanent connection with the molded polymer part 6, to provide a very inherently appearing flock surface, upon the molded part, when finished. Thus, the thermal setting polymer material directly cross links with the molding polymer substance, in the injection molding process, and cures with it, to form a permanently flocked product.

Since the flock of the transfer forms interstitial spaces between fibers, it is desirable to form a barrier between the mold and the perimeter of the transfer to prevent the resin from entering these interstitial spaces during injection of the resin into the mold. Referring to FIG. 3, a barrier 40 may be formed around the transfer 42. Barrier 40 can be formed during the fabrication of the flock transfer, by providing an excess of binder adhesive 10 around the edge of the transfer. The excess binder adhesive 10 will form a rib or dam around the periphery of the transfer.

Alternatively, referring to FIG. 4, the mold 50 may be provided with a barrier 52, which surrounds transfer 54 when the transfer is placed in the mold. Barrier 52 may be an integral part of mold 50, or may be a separate, added barrier which is composed of silicone, latex or other suitable sealing material.

-7-

Claims

1. A method of decorating a molded article comprising:
providing a transfer having a flocking layer, a release sheet on one side of
the flocking and a layer of binder adhesive on an opposite side of the
5 flocking;
securing the release sheet to an interior wall of a mold in which the
article is made; and
molding the part such that resin contacts the layer of binder
adhesive;
10 cooling the mold;
ejecting the part; and
removing the release sheet from the transfer.
2. The method of claim 1 wherein the release sheet is affixed
to the mold base with an adhesive.
- 15 3. The method of claim 1 wherein the release sheet is affixed
to the mold by vacuum.
4. The method of claim 1 including a step of preventing the
resin from entering interstitial spaces between the flocking.
5. The method of claim 4 wherein the preventing step includes
20 forming a dam around the perimeter of the transfer.
6. The method of claim 5 wherein the dam is formed by
placing a barrier in the mold, the transfer being positioned within the
barrier.
7. The method of claim 5 wherein the dam is part of the
25 transfer, the dam comprising a built up section of binder adhesive around
the periphery of the transfer.
8. A method of decorating a molded article comprising:
coating a release sheet with a release adhesive;

1/2

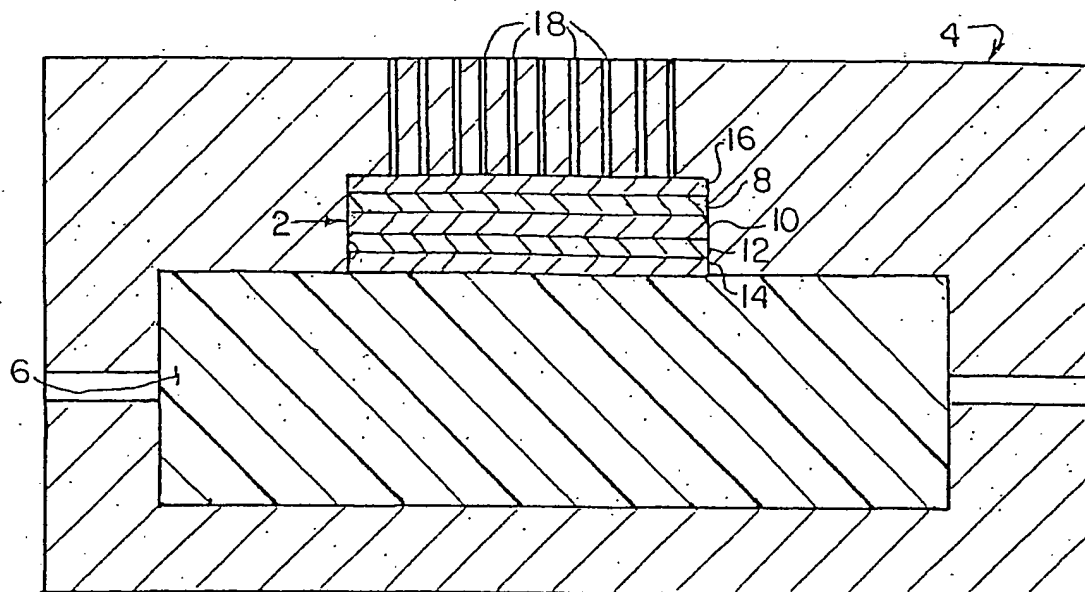


FIG. 1

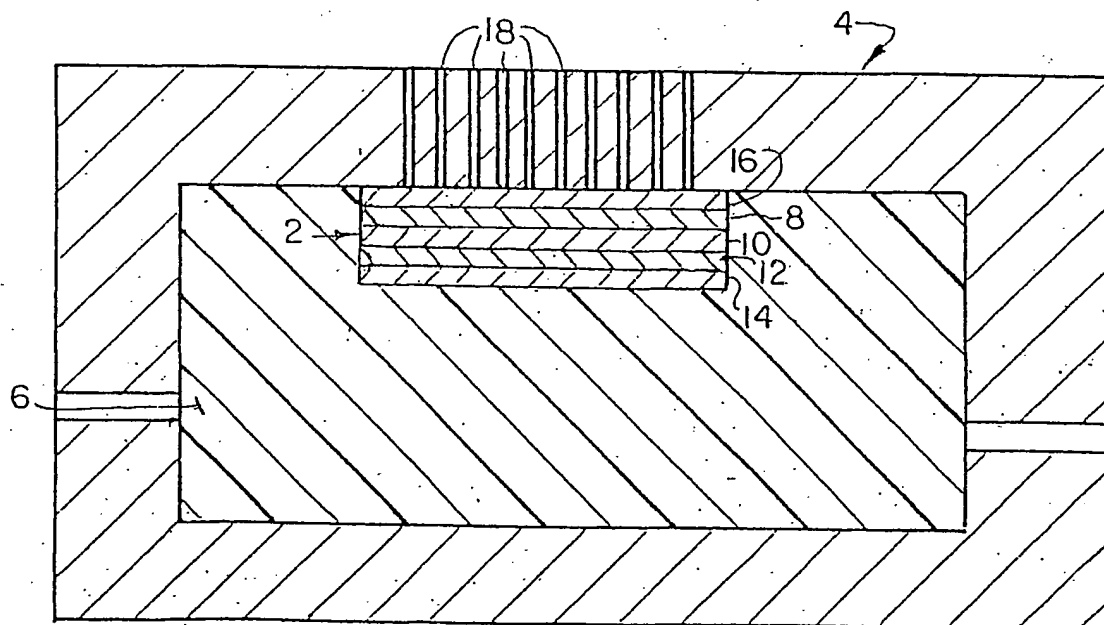


FIG. 2

2/2

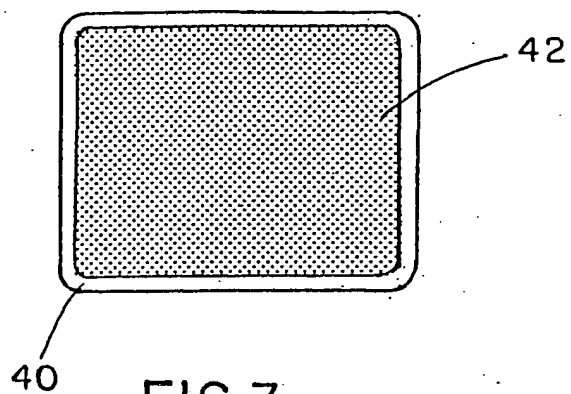


FIG. 3

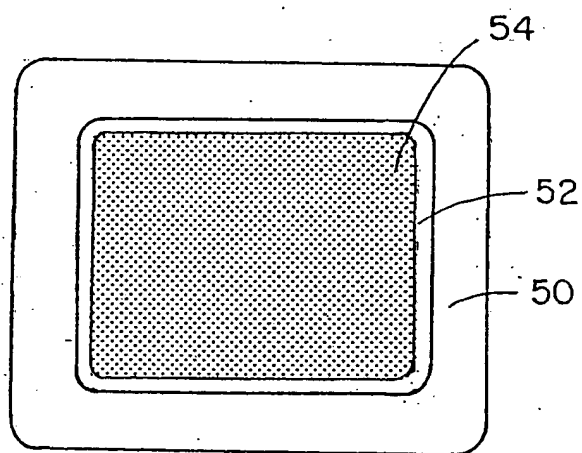


FIG. 4

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US01/23278

A. CLASSIFICATION OF SUBJECT MATTER IPC(7) : B29C 45/14 US CL : 264/511, 257, 275, 316 According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED Minimum documentation searched (classification system followed by classification symbols) U.S. : 264/511, 257, 275, 316 Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) EAST		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 4,292,100 A (HIGASHIGUCHI) 29 September 1981(29.09.1981), see entire document.	1-13
Y	US 4,314,813 A (MASKAI) 09 February 1982 (09.02..1982), see entire document.	1-13
Y	US 3,956,552 A (GEARY) 11 May 1976 (11.05.1976), see entire document.	1-13
Y	US 4,369,157 A (CONNER) 18 January 1983 (18.01.1983), see entire document.	1-13
Y	JP 356058824 A (KONDO et al) 22 May 1981 (22.05.1981), see entire document.	1-13
Y	JP 20000084977 A (IRIYAMA) 28 March 2000 (28.03.2000), see entire document.	1-13
Y	JP 359115885 A (SHIMIZU et al) 04 July 1984 (04.07.1984), see entire document.	1-13
<input type="checkbox"/> Further documents are listed in the continuation of Box C. <input type="checkbox"/> See patent family annex.		
* Special categories of cited documents: "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search 12 September 2001 (12.09.2001)		Date of mailing of the international search report 19 NOV 2001
Name and mailing address of the ISA/US Commissioner of Patents and Trademarks Box PCT Washington, D.C. 20231 Facsimile No. (703)305-3230		Authorized officer EDMUND H LEE Telephone No. 703.308.0661